

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009386**Date Inspected:** 28-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 01

Submerged Arc Welding Process:

Welding of weld joint -001,004 located on PCMK CB202C-015. Welder is identified as 215548. ZPMC QC is identified as Tain Lie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

OBG # BAY 02

Flux Cored Arc Welding Process:

Welding of weld joint -036,037 located on PCMK FB3093. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding of weld joint –026,027 located on PCMK FB3012-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –023,024 located on PCMK FB3026-001. Welder is identified as 203871. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 06

Flux Cored Arc Welding Process:

Welding of weld joint –114,112 located on PCMK CB202G-019. Welder is identified as 053742. ZPMC QC is identified as Liu chuan gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –114,112 located on PCMK CB202G-020. Welder is identified as 053609. ZPMC QC is identified as Liu chuan gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # BAY 05 (Cross Beam 16)

During in-process visual inspection of the OBG Cross Beam 16 components in Bay 5, This QA inspector witnessed that ZPMC QC Personal discovered a total of twenty two (22) Rejectable indications while performing Ultrasonic Testing for the following Cross beam components.

(205B-052-005,006)
(205C-051-005,006)
(205B-051-006,009)
(205C-052-005,006)
(205D-050-046)
(205D-051-043)
(205F-051-019,016)
(205F-049-016)
(205E-050-031,025,034)
(205E-049-031,034)
(205F-052-022,016,019)
(205C-050-005)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
